



Dart Aerospace Ltd.
1270 Aberdeen St
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D2893-1**Job Sheet 213685****Part No:** D2893-1**Job Qty:** 12 pcs**Part Name:** Support**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 10/1/20**Job Tracking No:****Due Date:** 11/30/20**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG D2893 REV D IPP: C 02.11.26 Reformat; Added P/O KJ IPP D 06.04.19 removed alodine EC IPP Rev:E
Added priming as per Rev B 07-04-30 JLM IPP F 08.03.19 Re-format EC verified by: DD IPP Rev:G 08-05-15
add QC14 DD verified by:EC IPP Rev:H 11.08.04 as per dwg rev.C ver:ECDWG /IPP Rev. I 19.10.01 New
issue DP Verify DD

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	HAAS 4 Axis	12 pcs	11/28/20		2.00	30.00	HAAS - 1	
							HAAS - 2	
							HAAS - 3	
							HAAS - 4	J.L.L. 20-11-02
120	QC 8	12 pcs	11/28/20		0.00	0.00	QC 8 - 12	
							QC 8 - 14	OK 20/11/22
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
							QC 8 - 47	
							QC 8 - 40	
							QC 8 - 52	
							QC 8 - 23	
							QC 8 - 57	



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Container No: S310036**Part:** D2893-1**Job No:** 213685**Serial No/Batch:** S310036**Revision:** D**Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 11/02/20

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					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
130	Crosstubes - 2 - B4B	12 pcs	11/30/20	0.00 2.00	Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	DAS
					Crosstubes - 3 - B4B	41 NOV 25 2020
					Crosstubes - 4 - B4B	3-89
140	QC 3	12 pcs	11/30/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	DAS NOV 26 2020 40
					QC 3 - 19	3-89
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
					QC 3 - 87	
					QC 3 - 47	
170	Packaging 3-1 - Stock - B4B	12 pcs	11/30/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	DAS NOV 26 2020
					Packaging 3 - 22 - B4B	41
					Packaging 3 - 23 - B4B	3-89
					Packaging 3 - 24 - B4B	

				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180 QC 21 - SA	12 pcs	11/30/20	0.00 0.00	QC 21 - SA - 21	DAS NOV 26 2020
				QC 21 - SA - 70	21
				Broussard	9-88
				QC 21 - SA - 9	
				QC 21 - SA - 77	
				QC 21 - SA - 28	
Part Op 100 - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA081 Descriptions: 120 - (QC8- Inspect parts - second check) 130 - (Crosstubes) Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and use DT10660 apply 3M Scotch-Weld as per dwg. <i>5206979 exp 8/21</i> 140 - (QC3- Inspect Part Finish) 170 - (Identify as per dwg & Stock Location: _____) LOCATION <u>LG050</u> 180 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
DSK078	D2893-1 Turning Detail	6 pcs (.5 ea)	100-HAAS 4 Axis	<i>5208 677</i>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-HAAS 4 Axis	DSK078	6	10	0	

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.750 Support	2.985Inches + 0.020 - 0.000	3.005 2.985		
2	2.750 Support	0.440Inches + 0.020 - 0.000	0.460 0.440		
3	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
4	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
5	2.750 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
6	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
7	2.750 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
8	2.750 Support	1.360Inches + 0.040 - 0.000	1.400 1.360		
9	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
10	2.750 Support	1.190Inches + 0.040 - 0.000	1.230 1.190		
11	2.750 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
12	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
13	2.750 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
14	2.750 Support	2.518Inches + 0.020 - 0.000	2.538 2.518		
15	2.750 Support	84.390Inches + 6.000 - 0.000	90.390 84.390		
16	2.750 Support	0.261Inches + 0.005 - 0.000	0.266 0.261		
17	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		

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DART AEROSPACE LTD		Work Order: 213685
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.125	0.160		.145	.140	.140	.145	.145
AB	0.040	0.060		.052	.052	0.050	0.050	.050
AC	Ø0.260	Ø0.266		.261	.261	.261	.261	.261
AD	Ø0.187	Ø0.143		.188	.188	.188	.188	.188
AE	0.240	0.250		.250	.250	.250	.250	.250
AF	1.347	1.407		1.365	1.371	1.366	1.367	1.368
AG	1.200	1.240		1.210	1.210	1.200	1.211	1.212
AH	0.147	0.167		.150	.160	.165	.157	.158
AI	2.985	3.005		3.000	2.998	2.999	2.998	3.000
AJ	0.400	0.500		.470	.460	.460	.460	.460
AK	4.930	4.990		4.958	4.959	4.955	4.956	4.954
AL	0.125	0.160		.140	.140	.140	.140	.140
AM	R0.053	R0.073		.063	.063	.063	.063	.063
AN	R0.240	R0.260		.250	.250	.250	.250	.250
AO	R0.021	R0.041		.031	.031	.031	.031	.031
AP	0.150	0.180		.168	.163	.168	.167	.167
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	2.302	2.322		2.320	2.320	2.320	2.320	2.320
AS	0.140	0.160		.145	.145	.155	.155	.155
AT	0.040	0.060		.055	.050	.049	.055	.054
Accept/Reject								

Measured by: J.C.V. **Date:** 20-11-01

Audited by: J.C.V. **Date:** 20/11/22

Preliminary Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	
E	20.02.10	Dwg Rev and Dimensions updated.	MG	DP

DART AEROSPACE LTD		Work Order: 213685	
Description: Ø2.750 Support		Part Number: D2893-1	
Inspection Dwg: D2893	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6 1	7 2	8 3	9 4	10 5
HAAS Section								
AA	0.125	0.160		.145	.145	.145	.145	.145
AB	0.040	0.060		.050	.050	.050	.050	.050
AC	Ø0.260	Ø0.266		.261	.261	.261	.261	.261
AD	Ø0.187	Ø0.193		.188	.188	.188	.188	.188
AE	0.240	0.250		.250	.250	.250	.250	.250
AF	1.347	1.407		1.368	1.368	1.368	1.368	1.369
AG	1.200	1.240		1.207	1.209	1.210	1.209	1.214
AH	0.147	0.167		.160	.160	.159	.156	.156
AI	2.985	3.005		2.999	2.999	2.998	2.995	2.995
AJ	0.400	0.500		.460	.460	.460	.460	.460
AK	4.930	4.990		4.955	4.955	4.955	4.955	4.955
AL	0.125	0.160		.140	.140	.140	.140	.140
AM	R0.053	R0.073		.063	.063	.063	.063	.063
AN	R0.240	R0.260		.250	.250	.250	.250	.250
AO	R0.021	R0.041		.031	.031	.031	.031	.031
AP	0.150	0.180		.167	.167	.167	.166	.167
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	2.302	2.322		2.320	2.320	2.320	2.320	2.320
AS	0.140	0.160		.155	.155	.155	.155	.152
AT	0.040	0.060		.047	.050	.052	.051	.054
Accept/Reject								

Measured by: J.C.C.	Date: 20-11-02
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Audited by: J.K.	Date: 20/11/22
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Preliminary Approval:	Date:
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Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
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DART AEROSPACE LTD		Work Order: 213685
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11 1	12 2	3	4	5
HAAS Section								
AA	0.125	0.160		.145	.145			
AB	0.040	0.060		.050	.050			
AC	Ø0.260	Ø0.266		.261	.261			
AD	Ø0.187	Ø0.143		.188	.188			
AE	0.240	0.250		.250	.250			
AF	1.347	1.407		1.370	1.369			
AG	1.200	1.240		1.208	1.211			
AH	0.147	0.167		.160	.160			
AI	2.985	3.005		2.991	2.998			
AJ	0.400	0.500		.460	.460			
AK	4.930	4.990		4.955	4.955			
AL	0.125	0.160		.140	.140			
AM	R0.053	R0.073		.063	.063			
AN	R0.240	R0.260		.250	.250			
AO	R0.021	R0.041		.031	.031			
AP	0.150	0.180		.167	.167			
AQ	0.053	0.073		.063	.063			
AR	2.302	2.322		2.320	2.320			
AS	0.140	0.160		.150	.150			
AT	0.040	0.060		0.046	.054			
Accept/Reject								

Measured by: J.C.L. **Date:** 20-11-02

Audited by: JKL **Date:** 20/11/22

Preliminary Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	
E	20.02.10	Dwg Rev and Dimensions updated.	MG <i>mg</i>	DP

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					